

5107

DART AEROSPACE LTD.	Work Order :	22221
Description: 206 Saddle, Outboard, Left Side	Part Number:	D2665-1
Drawing: D2665 Rev B	Qty:	8

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order Dwg. not required RF 02/09/16	DA	05.01.13	8
2	STORES	Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length (D6101-003) RF 02/09/16 Batch No: B209B8B	EP	05/02/10	8
3	HAAS	Program batch number.	EP	05/02/10	8
4	QC	Inspect part number and batch number are programmed correctly.	EP	05/02/10	8
5	HAAS	Fixturing W/O No. <u>N/A</u> Fixturing Inspection last completed on <u>05/02/10</u> by <u>EP</u>	EP	05/02/10	8
8	HAAS	Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet	EP	05/02/10	8
9	HAAS	Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet	EP	05/02/10	8
10	HAAS	Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet	EP	05/02/10	8
11	LAGUN	Machine Keyway and inspect per attached dimension sheet	EP	05/02/10	8
12	METAL	Deburr	EP	05/02/10	8
13	HAAS	Inspect Level 1	EP	05/02/10	8
14	QC	Inspect Level 8	EP	05/02/10	8
15	METAL	Acid etch and Alodine as per QSI 005 4.1	MM	05/02/10	8
16	FINISHING	Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3	MM	05/02/10	8
17	QC	Inspect Level 3	CL	05/02/10	8
18	STORES	Pack in foam, identify and stock.	CL	05/02/10	8
19	EXPEDITING	Close Work Order Job Cost / Part 88.19 SAE 05/02/24 (8)	DA	05.03.02	8

Rev	Date	Change	Revised By	Approved
A	97.07.24			
B	98.09.02	Inspection Levels, Added Powder Coat	KS	
C	00.11.01	Removed P/O for Powder Coat – in house process	EC	

RELEASED

EC DEC 18 2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	22221
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.131	0.132	0.132	0.134		
B	0.100	0.140		0.134	0.135	0.131	0.132		
C	0.100	0.140		0.125	0.128	0.127	0.127		
D	0.210	0.230		0.219	0.219	0.221	0.219		
E	1.245	1.255		1.248	1.249	1.251	1.249		
F	1.245	1.255		1.248	1.249	1.251	1.249		
G	5.990	6.010		6.000	5.999	5.999	6.002		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.674	1.684		1.678	1.678	1.678	1.678		
J	2.495	2.505		2.499	2.500	2.499	2.499		
K	0.257	0.262	DT8683	—	—	—	—		
L	0.312	0.317	DT8686	—	—	—	—		
M	0.235	0.240		0.235	0.235	0.235	0.235		
N	0.100	0.140		0.119	0.120	0.118	0.119		
O	0.540	0.560		0.549	0.546	0.546	0.546		
P	0.490	0.510		0.500	0.502	0.498	0.502		
Q	3.609	3.619		3.614	3.614	3.614	3.611		
R	2.470	2.510		2.499	2.499	2.501	2.499		
S	0.240	0.270		0.254	0.257	0.253	0.254		
T	0.100	0.180		0.140	0.135	0.135	0.135		
U	0.313	0.318	DT8686	—	—	—	—		
V	1.125	1.145		1.133	1.133	1.133	1.133		
W	1.565	1.585		1.570	1.570	1.571	1.572		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	EP	Audited by:	jm
Date:	05/02/19	Date:	05/02/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	#

DART AEROSPACE LTD

Work Order:

22221

Description: 206 Saddle, Outboard, Left side

Part Number:

D2665-1

Inspection Dwg: D2665 Rev. B

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Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.133	0.133	0.133	0.136		
B	0.100	0.140		0.131	0.131	0.131	0.132		
C	0.100	0.140		0.129	0.127	0.128	0.124		
D	0.210	0.230		0.225	0.222	0.218	0.215		
E	1.245	1.255		1.251	1.245	1.245	1.245		
F	1.245	1.255		1.251	1.249	1.245	1.245		
G	5.990	6.010		6.001	5.998	6.002	6.002		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.674	1.684		1.670	1.678	1.679	1.679		
J	2.495	2.505		2.499	2.499	2.501	2.500		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		0.235	0.235	0.235	0.235		
N	0.100	0.140		0.119	0.119	0.117	0.117		
O	0.540	0.560		0.545	0.545	0.545	0.543		
P	0.490	0.510		0.499	0.499	0.498	0.499		
Q	3.609	3.619		3.612	3.612	3.612	3.612		
R	2.470	2.510		2.499	2.495	2.499	2.499		
S	0.240	0.270		0.254	0.254	0.254	0.254		
T	0.100	0.180		0.135	0.135	0.135	0.135		
U	0.313	0.318	DT8686						
V	1.125	1.145		1.134	1.133	1.134	1.135		
W	1.565	1.585		1.569	1.569	1.569	1.571		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: *SP*
 Date: 05/02/11

Audited by: *TML*
 Date: 05/02/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF <i>RF</i>	<i>#</i>

Job Costing Report

Dart Aerospace Ltd.
HawkesburyJan 13, 2005
10:56 am

Work Order No : 0022221
 Project Name : D2665-1
 Project For : WK507
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2665-1
 Description : Saddle, LH Fwd Aft Out
 Manufactured : Yes
 Amount Req'd : 8
 Amount Done : 0
 Start Date : 01-13-05
 Est Finish Date : 02-15-05
 Act Finish Date :
 Drawings Rqd : No
 Ok for Approval :
 Approval Rec'd :
 Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
MISC. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00